

slp 10/03

# Work Order ID 67158

Wednesday, March 09, 2011 11:33:44 AM



## PRELIMINARY ISSUE

Page 1

Item ID:	D4165-3	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Inner Door Panel					
Start Date:	3/9/2011	Start Qty:	1.00			
Required Date:	3/10/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4165	PA1								
100		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
2024.040	Dwg Rev: PA1								
	Prog Rev: PA1								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

1311-3-9

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1311-3-9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 67158

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Item ID: D4165-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Inner Door Panel

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 - inspected to PA1 Dry only 8/10/09		(X)					
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							
135  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							

1 BR 11-3-9

1-6 H 11/03/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries

**Work Order ID 67158**

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Page 3

Item ID: D4165-3

Accept

Revision ID: PRELIM

Item Name: Inner Door Panel

Start Date: 3/9/2011 Start Qty: 1.00

Required Date: 3/10/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

11/3/10

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/3-10

~~11/23/10~~  
Roberto

POSITIVE RECALL

EFFECTIVE 11/30/09 AUTH LL

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 11:33:42 AM

Page 1

Work Order ID: 67158



Parent Item: D4165-3



Parent Item Name: Inner Door Panel

Start Date: 3/9/2011

Required Date: 3/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	184.0595	3.58	3.768421			
2024-T3 .040 sheet													



IB 11-3-9

Location	Loc Qty	Loc Code
MAT	11.8	
114415	11.8	
MAT22	172.2595	
110305	21.93	
111786	7.66	
112291	14.25	
112331	52	
113162	76.4195	

116385

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

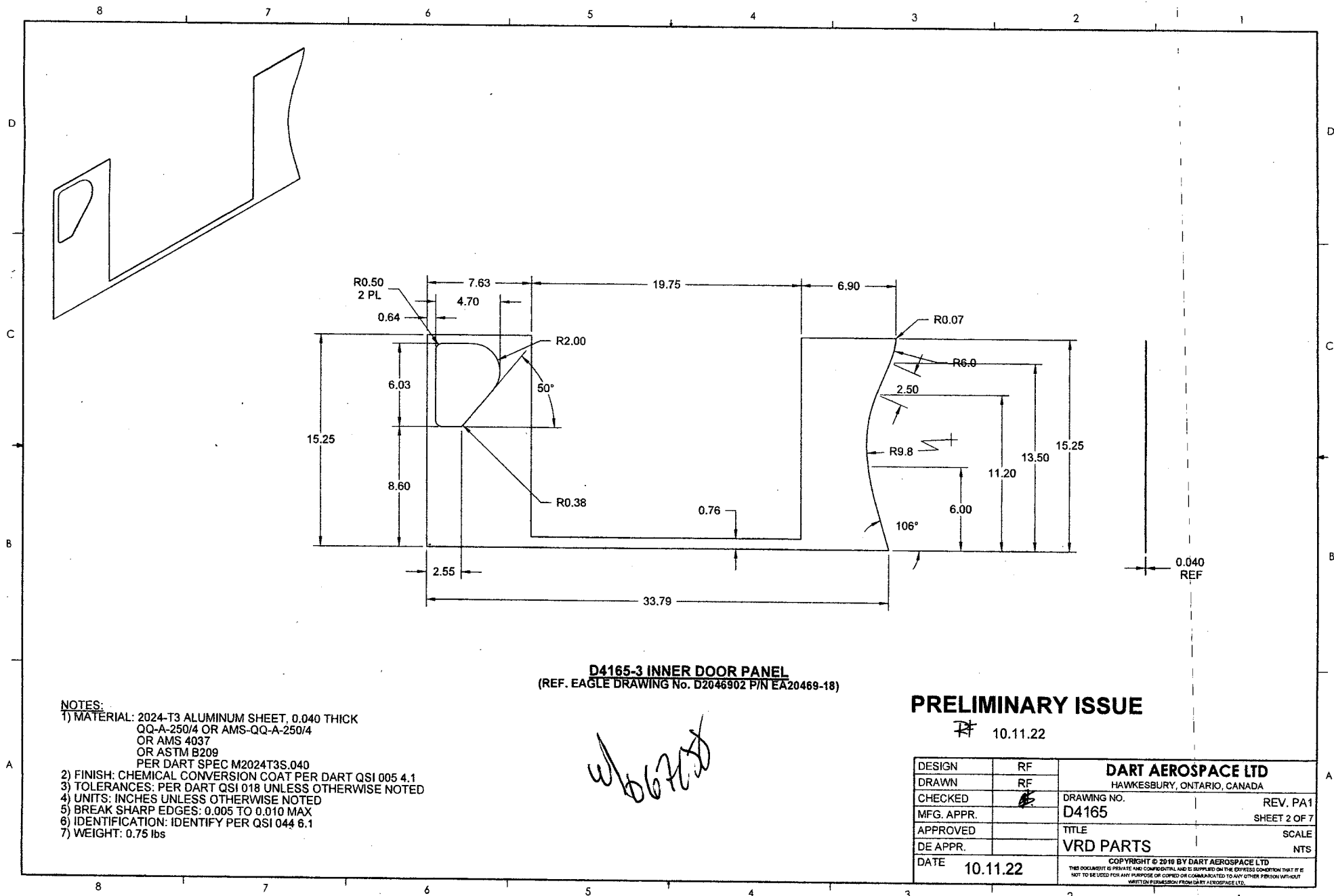
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4165-3 INNER DOOR PANEL**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-18)

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK  
QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037  
OR ASTM B209  
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.75 lbs

**PRELIMINARY ISSUE**

10.11.22

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4165</b>	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>VRD PARTS</b>	NTS
DATE	<b>10.11.22</b>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

